

DAS
27
9-8

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 145795

Friday, May 06, 2016 10:53:22 AM

145795

Page 2

Item ID: D412-704-015

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Co-Pilot's Emergency Cargo Release

Start Date: 5/4/2016 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 5/11/2016 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging				DAS 28 9-89				
Packaging	Memo	0.00			DAS 27 9-89				
Packaging	Identify and pack for shipping as per PPP D412-704-015 Location: <u>9/8</u> PPP Rev: _____	<i>Sold</i>			JUN 15 2016				
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.20							
Quality Control									

5th 6/15/16

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Page 1

Work Order ID: 145795

145795

Parent Item: D412-704-015

D412-704-015

Parent Item Name: Co-Pilot's Emergency Cargo Release

Start Date: 5/4/2016

Required Date: 5/11/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 12-03-22 JLM VERIFIED BY:EC
REV:B 12.04.20 per cen-566 DD verf:EC
12.05.10 per ECN 12-583 DD verf:EC
IPP
IPP REV:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D412-704-141		Manufactured	No			110	Each	0.0000	1	2			DAS 28 9-89
D412-704-141									**	1 x 14768p		DAS 6 9-89	JUN 14 2016
Pedal Assembly													
D412-704-045		Manufactured	No			110	Each	4.0000	1	2			
D412-704-045									**				
Cable Ass'y													DAS 28 9-89
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST215			4					
					144248			4					
D3207-5		Manufactured	No			110	Each	9.0000	1	2			
D3207-5									**				DAS 28 9-89
Bracket													
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST024			9					
					116991			9					
D3207-7		Manufactured	No			110	Each	8.0000	1	2			
D3207-7									**				DAS 28 9-89
Packer													
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST024			8					
					110077			8					

DQA: _____ Date: _____

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
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Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

Picklist Print

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Page 2

Work Order ID: 145795

145795

Parent Item: D412-704-015

D412-704-015

Parent Item Name: Co-Pilot's Emergency Cargo Release

Start Date: 5/4/2016

Required Date: 5/11/2016

Start Qty: 2.00

Required Qty: 2.00

D3207-9

Manufactured No

110

Each

7.0000

1 2

D3207-9

Bracket

**

DAS
6
9-89
28
9-89

Location

Loc Qty

Loc Code

ST024

7

122604

7

D3208-1

Manufactured No

110

Each

17.0000

1 2

D3208-1

Doubler

**

DAS
8
9-89

Location

Loc Qty

Loc Code

ST025

17

141492

17

D3208-11

Manufactured No

110

Each

18.0000

1 2

D3208-11

Filler

**

DAS
6
9-89

Location

Loc Qty

Loc Code

ST026

18

141386

18

D3208-3

Manufactured No

110

Each

2.0000

1 2

D3208-3

Pedal Mount Angle

**

DAS
6
9-89

Location

Loc Qty

Loc Code

ST025

2

117181

2

D3208-7

Manufactured No

110

Each

3.0000

1 2

D3208-7

Filler

**

DAS
6
9-89
28
9-89
MAY 17 2016

Location

Loc Qty

Loc Code

ST025

3

119559

3

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Page 2

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Picklist Print

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Work Order ID: 145795

145795

Parent Item: D412-704-015

D412-704-015

Parent Item Name: Co-Pilot's Emergency Cargo Release

Start Date: 5/4/2016

Required Date: 5/11/2016

Start Qty: 2.00

Required Qty: 2.00

D3208-9

Manufactured No

110

Each

14.0000

1 2

D3208-9

Doubler

**

DAS
27
9-89

Location

Loc Qty

Loc Code

ST025

14

142241

14

2

D3214-1

Manufactured No

110

Each

17.0000

1 2

D3214-1

Decal

**

DAS
27
9-89

Location

Loc Qty

Loc Code

ST026

17

141572

17

2

D4610-1

Manufactured No

110

Each

10.0000

1 2

D4610-1

Doubler

**

DAS
27
9-89

Location

Loc Qty

Loc Code

ST112

10

119696

10

2

D4610-3

Manufactured No

110

Each

19.0000

1 2

D4610-3

Doubler

**

DAS
27
9-89

Location

Loc Qty

Loc Code

ST112

19

142233

19

2

D4610-7

Manufactured No

110

Each

23.0000

1 2

D4610-7

Cover

**

DAS
27
9-89

Location

Loc Qty

Loc Code

ST112

23

142239

23

2

DAS
8
9-89

DAS
28
9-89

DAS
8
9-89

DAS
28
9-89

DAS
8
9-89

DAS
28
9-89

DAS
8
9-89

DAS
28
9-89

DAS
8
9-89

DAS
28
9-89

MAY 17 2016

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Shop Packet Print

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DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

Picklist Print

Page 4

Friday, May 06, 2016 10:53:22 AM

Work Order ID: 145795

145795

Parent Item: D412-704-015

D412-704-015

Parent Item Name: Co-Pilot's Emergency Cargo Release

Start Date: 5/4/2016

Required Date: 5/11/2016

Start Qty: 2.00

Required Qty: 2.00

MS21919-DG5

Purchased

No

110

Each

24.0000

4

8

MS21919-DG5

Clamp

DAS
27
9-89

Location

Loc Qty

Loc Code

ST293

24

m134134

24

**

M16984

DAS
28
9-89

D4622-1

Manufactured

No

110

Each

6.0000

1

2

D4622-1

Placard

DAS
27
9-89

Location

Loc Qty

Loc Code

st113

6

132587

6

**

2

DAS
28
9-89

D4622-3

Manufactured

No

110

Each

8.0000

1

2

D4622-3

Placard

DAS
27
9-89

Location

Loc Qty

Loc Code

st113

8

132697

8

**

2

DAS
8
9-89

DAS
28
9-89

MS35489-149

Purchased

No

110

Each

88.0000

1

2

MS35489-149

GROMMET

DAS
27
9-89

Location

Loc Qty

Loc Code

ST269

88

121692

88

**

2

DAS
8
9-89

DAS
28
9-89

MAY 17 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date: _____		Step #: _____		QTY Effective: _____			MRB (QSI042) Approval				
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval			
Root Cause		FAULT CATEGORY									
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER: _____									
Misidentified ☐	Past Due ☐										

5.0 PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -041	Qty -141	Qty -043	Qty -045	Part Number	Description
X							D412-704-011	COPILOT'S EMERGENCY CARGO RELEASE KIT (210/212/214)
	X						D205-704-013	COPILOT'S EMERGENCY CARGO RELEASE KIT (205)
		X					D412-704-015	COPILOT'S EMERGENCY CARGO RELEASE KIT (412)
1	1		X				D412-704-041	PEDAL ASSEMBLY (205/210/212/214)
		1		X			D412-704-141	PEDAL ASSEMBLY (412)
	1				X		D205-704-043	CABLE ASSEMBLY (205)
1		1				X	D412-704-045	CABLE ASSEMBLY (210/212/214/412)
			1	1			D3204-041	PEDAL ASSEMBLY (OR ECM 999702-1)
			1	1			D3205-1	PEDAL BRACKET (OR ECM 999703-1)
			1	1			D3205-3	BACK PLATE (OR ECM 999709-5)
			1	1			D3206-1	PEDAL ARM (OR ECM 999704-1)
	1						D3207-1	BRACKET
	1						D3207-3	BRACKET
1		1					D3207-5	BRACKET
1	1	1					D3207-7	PACKER
		1					D3207-9	BRACKET
1							D3207-11	BRACKET
1	1	1					D3208-1	DOUBLER (OR ECM 999709-1)
1	1	1					D3208-3	PEDAL MOUNT ANGLE (OR ECM 999709-7)
	1						D3208-5	MOUNT ANGLE
1	1	1					D3208-7	FILLER (OR ECM 999709-3)
1		1					D3208-9	DOUBLER
1		1					D3208-11	FILLER
			1	1			D3209-041	BRACKET ASSEMBLY (OR BHT 204-070-993-001)
1	1	1					D3214-1	PLACARD (OR ECM 999712-1)
					1		D3217-1	CABLE
						1	D3217-3	CABLE
					1	1	D3257-1	FITTING
					1	1	D3258-1	ANGLE BRACKET
		1					D4610-1	DOUBLER
		1					D4610-3	DOUBLER
			1	1			D4610-5	SHIM
		1					D4610-7	COVER
				1			D4611-1	BUSHING
		1					D4622-1	PLACARD
		1					D4622-3	PLACARD
			1	1	1	1	AN3-10A	BOLT
			1	1			AN315-4R	NUT
					1	1	AN3-5A	BOLT
			2	2			AN3-6A	BOLT
			1	1			AN4-10A	BOLT
			2				AN4-11A	BOLT
				2			AN4-12A	BOLT
			1				AN4-13A	BOLT
				1			MS20002-4	WASHER

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